

Work Order ID 80441

80441

Page 1

February-21-12 9:15:11 AM

Item ID: D3806-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 21/02/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: M.L.J.

Date: 12/02/12

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3806	B								

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 43.60"

25 12 03 04 (S12)

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB070 & dwg

FOLIO REV: 4A

DWG REV: B

2-Deburr as required

ml 12/03/08

20 0

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Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location

0.00

140

Packaging

Memo

0.00

Packaging

ST WA

20x Sp12-03-12

20x 12/03/08

20 x

20x 12/3/09

20 x

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/3/13

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Picklist Print

February-21-12 9:15:15 AM

Page 1

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Parent Item: D3806-1

D3806-1

Parent Item Name: Bar

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 08-07-21 new issue DD verified by:ec
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 IPP Rev:C 08-09-30 redesign DD verified by:EC
 D 11.06.03 re-design EC verified by:DD
 rev.b as per dwg DD verified by:EC

IPP rev
 IPP Rev:E 11.10.04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No				f	491.6000		76.48421			

M304B0 250x0 500

304 BAR .250 x .500

**

25 12-03-04

Location

Loc Qty

Loc Code

MAT006

491.6

120696

491.6

81.76

6 lengths
 x 87.2"

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Dart Aerospace Ltd

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8 7 6 5 4 3 2 1

D

D

D3806-1 BAR

D3806-5 BAR

C

C

D3806-3 BAR

D3806-7 BAR

B

B

RELEASED
2011-10-03

A

A

80441 M.C.J
12/02/21

B	REVISED D3806-1/3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PAR11-108		MB	11.09.29
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DRAWN		DART AEROSPACE USA, INC. KENT, WA	
CHECKED	MFG. APPR.		DRAWING NO.	REV. B
APPROVED	DE APPR.		D3806	SHEET 1 OF 3
DATE	11.09.29		TITLE	SCALE
			BAR	NTS
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8 7 6 5 4 3 2 1

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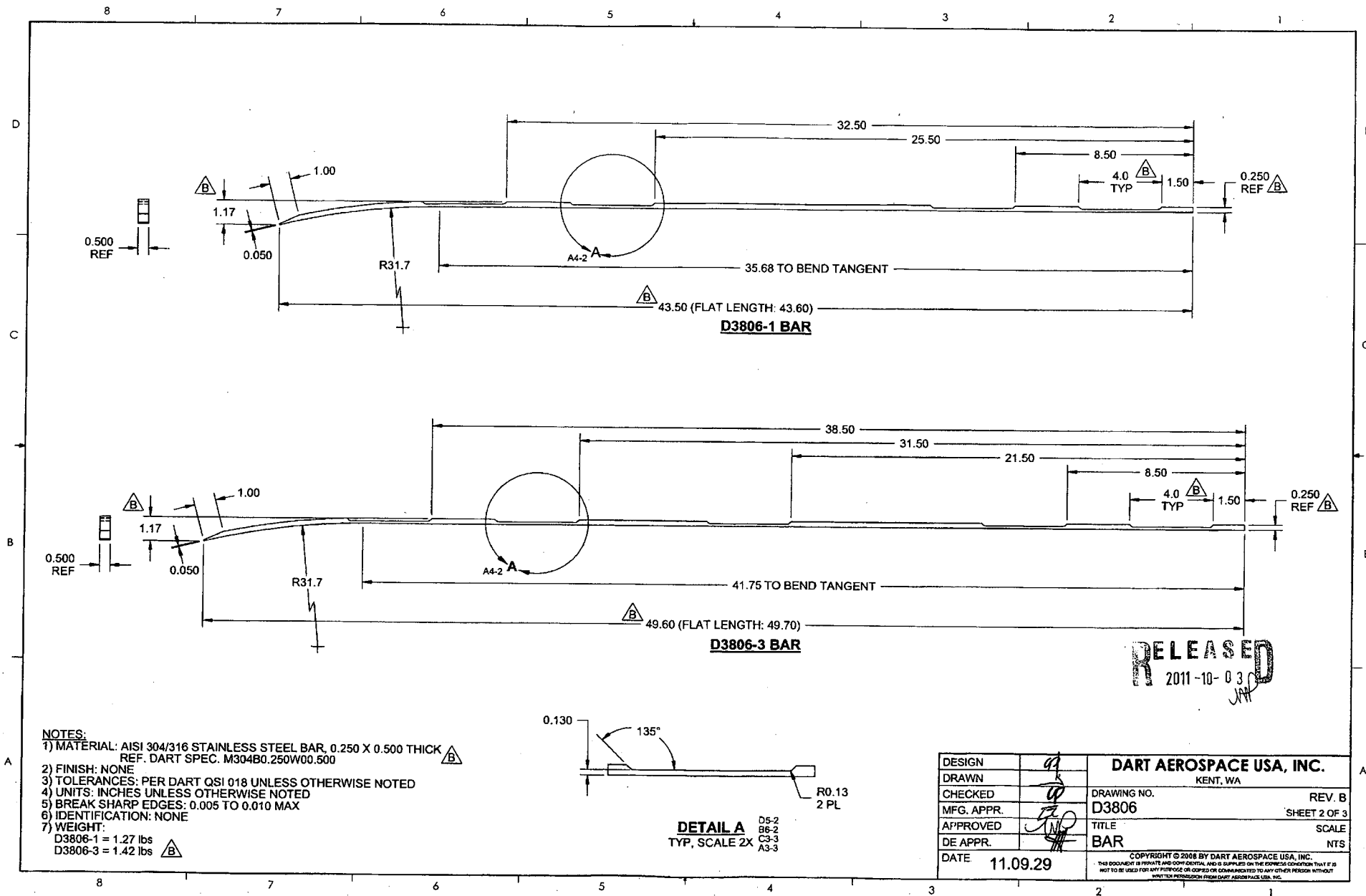
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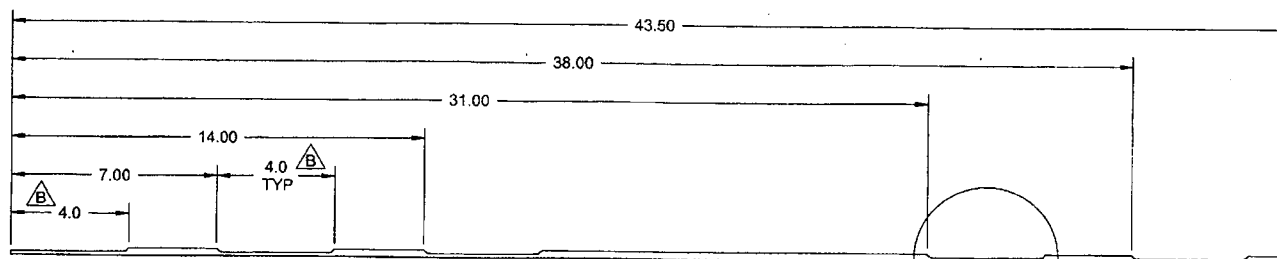
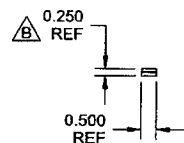
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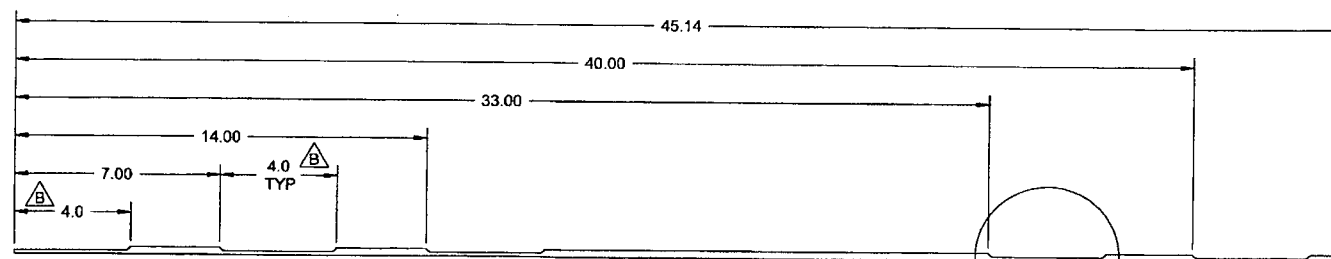
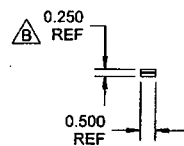
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D3806-5 BAR



D3806-7 BAR

RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3806	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
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